Work Order Thursday, October				*125	5597*							Page 1
Revision ID:	574-2 bin Floor Pro	stactor		Accept	*N900	<u>040</u>	100)*	-	Start Stop		S1* S2*
Start Date: 10, Required Date: 10,	/16/14	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust Item l Customer:	D:						
	rocess Plan	: (1)	Date: <u> </u>	⊘ Tooling: SPC (Y/N):		ate:		1		Start Stop		R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr										
*100 *100 Waterjet FLOW CNC Waterjet		FLOW WATER JET Memo	_	0.00				2			DC1	4/10/18

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

110

110

Quality Control

DQA:		_ Date:	-									TAART
QA Closed:		Date:			WORK ORDER NON	-C	ONFO	RMANCE / UPDATE	W	ork Order u	ndate only	AEROSPACE
					DISPOSITION		Г				· · · · · · · · · · · · · · · · · · ·	
Work Orde	r:				DISPOSITION	_		AGAI	יט וצוי	PARTMENT	/PROCESS	
Part N	0				Rework Scrap		1	Skid-tube Crosst Machining Small	Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Suspected Unapproved		Thern	noforming Finish Large Fab Compo	~}	Rec/Sto	re/Packaging Supplier	Other
Root				Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Cl	nief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data												
quip/Tooling	_											
landling/Pre	_											
Material												
Operator		3										
Offset/Setup				<u> </u>								
rocess												
upplier	_											
raining												
ransport	_											
Inapproved		<u>.</u>	L	İ		_	LUTCAT	TCONY		<u> </u>		
Landin	a Goor				General	FA	ULT CAT	EGURY				
Landin	Bending				Bend	_	ادمانم/م	rogram		Outside Dim]n/r
-	Centre No	nt Concor	atric	-	BOM/Route		Grain	rogram	-	Over/Under	 	Pressure/Forced Set-up
}	Cracks	or concer	TO IC	-	Broken/Damage/Defect	\vdash	Hardwa	re	-	Part Incorre		Temperature/Cure
}	Crimp/Kir	nk/Rinnle	/Wave		Burrs	-	-	on Incomplete/Unqualified	-	Part Lost/Mi		Weld
-	Cuffs	, mppic	, wave		Contamination	\vdash	1	ions Incomplete/Unclear	-	Part Moved	331116	Wrong Stock Pulled
-	Crushing				Countersink		4	ned/off center		Positioned V	L Vrong	WTOING STOCK T UNCU
-	Heat Trea	nt			Cut Too Short		Mislabe		-	Power Loss/		Other
-	Inspection		Tube		Drawing	_	Misread		Ц.	1. 04461 2033/		0.1101
<u> </u>	Marks/Ch	•			Drill Holes	\vdash	Off-set					
<u> </u>	Turning S			H	Finish	\vdash	-1	Calibration			· · · · · · · · · · · · · · · · · · ·	
t	⊢ Wave/Tw				Fit/Function	\vdash	4	equence				

Work Orde Thursday, Octob					*125	5597*						Page 2
Item ID: Revision ID: Item Name:	D3574-2 Cabin Floor P	rotector			Accept	*N900	<u>0</u> 40	100)*	Setup Star	1 7	S1* S2*
	10/16/14 10/17/14	Start Qty: 2.00 Req'd Qty: 2.00		*9* *9*		Cust Item I	D:					,
Approvals:	Process Pla	nn:	Date:_		Tooling: _ SPC (Y/N):		ate:]	Run Star Sto	~I <i>V</i> I	R1* R2*
Sequence ID/ Work Center II 120 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 38 9-89 OCT 2 3 20
130 *120* Small Fab Small Fab		Small Fab Memo Deburr if ne	cessary.	plA	0.00 DASO 38 9-89							

0.00

QC5- Inspect part completeness to step on W/O

Memo

140

140

Quality Control

DQA:			Date:		·	WORK ORDER NON	-C(ONFO	RMANCE / UPDAT	ΓE			DART
QA Closed:			Date:								ork Order up	odate only	AEROSPACE
Work Orde	er:					DISPOSITION			AG	SAINST DE	PARTMENT,	/PROCESS	
Part N						Rework Scrap Use-as-is Suspected Unapproved			Machining Sm. noforming Fir	esstube all Fab nishing posite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descr	iption of work order update		Initial	Action		Sign &		
Cause		ate	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved										. `			
							FAI	ULT CAT	EGORY				
Landir	n g Gear Ber	nding	·			General Bend			rogram		Outside Dime	ensions	Pressure/Forced
•	Cer	tre No	t Concen	itric		BOM/Route		Grain	-		Over/Under	tolerance	Set-up
	Cra Crir		k/Ripple,	/Wave		Broken/Damage/Defect Burrs		Hardwa Inspecti	re on Incomplete/Unqualifie	ed	Part Incorred		Temperature/Cure Weld
ľ	Cuf	-				Contamination			ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		shing				Countersink		ł	ned/off center		Positioned W	<u> </u>	
		at Treat				Cut Too Short	-	Mislabe	·		Power Loss/S	_	Other
			Strip in	Tube	-	Drawing	1	Misread			·	~ <u>L</u>	•
		rks/Cha				Drill Holes	-	Off-set					
ľ			quence		-	Finish		i	Calibration				-
ľ	_		· st in Tub	e		Fit/Function		i	equence				

					F							
Work Ord				*125	5597*							Page
Item ID: Revision ID:	D3574-2			Accept	*N900	040	100)*	Setup		I	S1*
Item Name:	Cabin Floor	Protector								Stop	*N	S2*
Start Date: Required Date	10/16/14 :: 10/17/14	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						
Reference:			-									
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:			Run	Start	^I <i>V</i> I	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	ject y	Reject Number	Insp. Stamp
150		Identify as per dwg & St	ock Location:	0.00	4							
150 Packaging		Мето		0.00		OCT	3 1 20	14	DA: - - 0 8 9-8:	3		

160

Packaging

QC21- Final Inspection - Work Order Release

0.00

160

Quality Control

Memo

0.00

Page 3

DQA:		Date:			WORK ORDER MON		·	28448465 / 11			•			DART
QA Closed:		Date:			WORK ORDER NON	-C(JNFO	RIVIANCE / U	IPDATE	W	ork Order uj	odate only 「	\neg	AEROSPACE
					DISPOSITION				AGAINST		PARTMENT	· · · · · · · · · · · · · · · · · · ·		
Work Orde	er:					,					1		_	—
Dowt N	١				Rework	-		Skid-tube	Crosstube		,	Water Jet	_	Engineering
Part N					Scrap	-		Machining noforming	Small Fab	\vdash	4	d. Eng. Coor.	_	Quality
NCR N	lo.				Use-as-is Suspected Unapproved			Large Fab	Finishing Composite	-	Rec/Sto	re/Packaging Supplier	-	Other
										ا	.] 		/ 	
Root				Desci	ription of work order update		nitial	Ac	tion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
Design														
Doc/Data				<u> </u>										
Equip/Tooling												•		
Handling/Pre														
Material													ĺ	
Operator														
Offset/Setup														
Process														
Supplier														
Training														
ransport														
Jnapproved													l	
						FAL	JLT CAT	EGORY						
Landin	g Gear				General									
	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	Pr	essure/Forced
Γ	Centre No	ot Concer	ntric		BOM/Route	П	Grain				Over/Under	tolerance	Se	t-up
Γ	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	et 「	Te	mperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs	П	Inspecti	on Incomplete/U	nqualified		Part Lost/Mi	ssing	\neg w	eld
	Cuffs				Contamination		Instruct	ions Incomplete/I	Unclear		Part Moved		\exists_{w}	rong Stock Pulled
ľ	Crushing				Countersink	-		ned/off center			Positioned V	√rong		-
ľ	Heat Trea	ıt			Cut Too Short	—	Mislabe				Power Loss/:		Ot	her
	Inspection		Tube		Drawing		Misread							
	Marks/Ch	•			Drill Holes	-	Off-set							
	Turning S				Finish	-		Calibration						
	Wave/Tw	•			Fit/Function	-		equence						

⁶Picklist Print

Thursday, October 16, 2014 8:43:41 AM

Work Order ID: 125597

125597

Parent Item:

D3574-2

D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 10/16/14

Required Date: 10/17/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev : A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	5,896.686		51		,,	, (
*MI FXS 1	25-F60	029-04	*						**			Dely	10/10

GE PLASTICS LEXAN SHEET

Location	<u>l</u>	Loc Oty	Loc Code	
MAT019)	1590.095		
	124866	106		
	m126425	160.925		
	m127934	665		
	m128746	658.17		<u>46.666</u>
SABIC		2560		
	m130209	2560		www.
TPI		1746.59178		
	m129759	1746.59178		4.4.50

Page 1

DQA:			Date:			WORK ORDER NON	-C (ONFOI	RMANCE / LIE	PDATE			DART
QA Closed:			Date:			WORK ORDER NOR		J. 11 O.	MINIAMOL / OI		ork Order up	odate only	AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N	No			-		Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descr	iption of work order update		Initial	Acti	on	Sign &		
Cause	1	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FAI	ULT CAT	EGORY				
Landi	ng Gea	r				General		•			_		
	Cei Cra Cri Cui Cru He	acks mp/Kinl ffs ushing at Treat	t Concer k/Ripple : Strip in	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Grain Hardwa Inspecti Instruct	on Incomplete/Undions Incomplete/Undined/Off center led		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance et ssing /rong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	_	rks/Cha			-	Drill Holes	-	Off-set					
	_	-	quence st in Tub			Finish Fit/Function		1	Calibration Sequence				

DART AEROSPACE LTD	Work Order:	125597
Description: Cabin Floor Protector	Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
	THOUAIGIO	, lototype

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø3.00	+0.006/-0.001	3.00	/		V=JKM-01	
7.37	+/-0.030	7.37			T=JKM-06	
10.75	+/-0.030	10.75	-			
11.00	+/-0.030	11.00	/			
15.25	+/-0.030	15.25				
25.87	+/-0.030	25.87	/			
39.75	+/-0.030	39.75				
44.75	+/-0.030	44.75	/			
53.51	+/-0.030	53.51	/			
63.50	+/-0.030	63.51	/			
65.25	+/-0.030	65.25	7			
10.75	+/-0.030	10.75	_			······································
11.00	+/-0.030	11.00	J			
14.75	+/-0.030	14.75	/			· · · · · · · · · · · · · · · · · · ·
25.50	+/-0.030	25.30	/			
25.75	+/-0.030	25.75	/			
26.00	+/-0.030	26.00	7			
32.87	+/-0.030	3287				
38.81	+/-0.030	38.81	/			
45.00	+/-0.030	45.00				
48.25	+/-0.030	44.25	/			
58.38	+/-0.030	54.38				
61.25	+/-0.030	61.25	7			
64.13	+/-0.030	64.13	~			
64.63	+/-0.030	64.63				
66.50	+/-0.030	(6.50	7	-		
7.50	+/-0.030	7.50				
9.50	+/-0.030	9.50				
10.38	+/-0.030	10.38	_			
10.88	+/-0.030	10.89				
14.50	+/-0.030	14.50	/			
16.56	+/-0.030	16.56				
18.75	+/-0.030	18.75				
24.13	+/-0.030	24,13	J -		 	

DART AEROSPACE LTD	Work Order:	
Description: Cabin Floor Protector	Part Number:	D3574-2
Inspection Dwg: D3574 Rev. B		Page 2 of 2

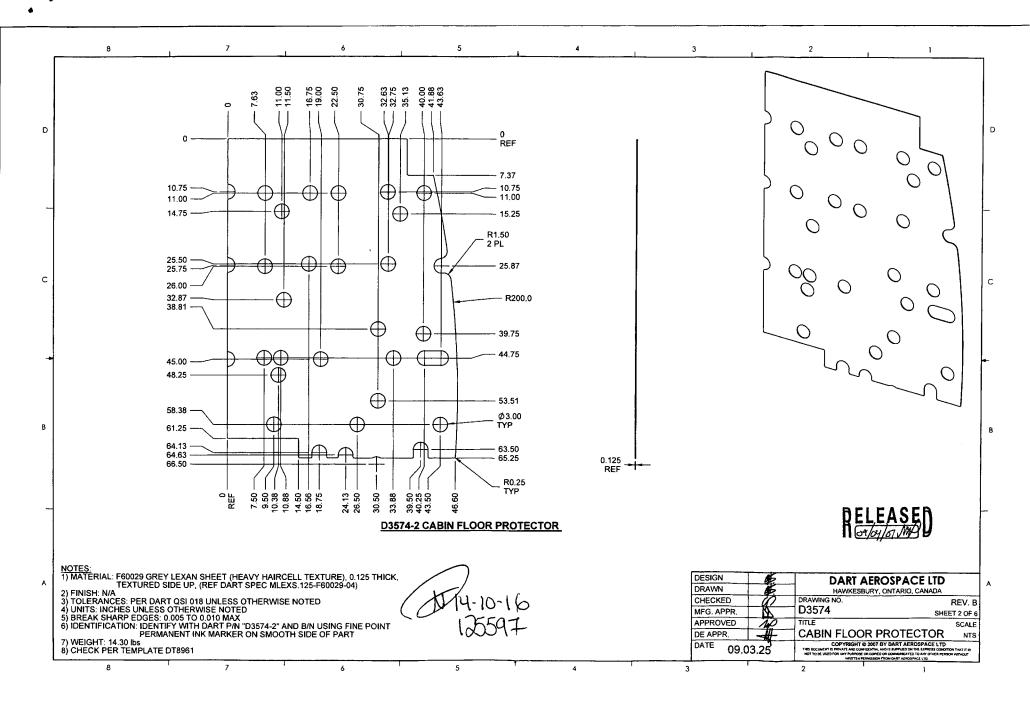
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50			V=5KM-01	
30.50	+/-0.030	30-50			T= JLM-06	
33.88	+/-0.030	33.88	_			
39.50	+/-0.030	39.50	_			
40.25	+/-0.030	46.25				
43.50	+/-0.030	43.50	/			
46.60	+/-0.030	46.60	~			
7.63	+/-0.030	7.63	_			٠.
11.00	+/-0.030	11.00	/			
11.50	+/-0.030	71.50	7			
16.75	+/-0.030	16.75	_			
19.00	+/-0.030	19.00	/			
22.50	+/-0.030	22.50	7			
30.75	+/-0.030	30.75	_			
32.63	+/-0.030	32.68	7			
32.75	+/-0.030	32-75				
35.13	+/-0.030	35.13	_			
36.50	+/-0.030	36.50	/			
40.00	+/-0.030	40.00				
41.88	+/-0.030	41.88	7			
43.63	+/-0.030	43.63	_			
0.125	+/-0.010	. 128	DAS			

Measured by:	De			Audite	ed by:	9-89	Prototype Approval:	N/A
Date:	14/	14 /	18		Date:	OCT 2 3 2014	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue	KJ//DD	
В	08.07.31	47.75 dimension removed	KJ/DD	,,
С	09.05.15	Dimensions updated per Dwg Rev B	KJ 94)-	N.



4.4